

Work Order ID 162717

Friday, June 09, 2017 10:41:56 AM

162717

Page 1

Item ID: D4820-3 Accept *N9000040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Fpc Clip Profile
 Start Date: 6/9/2017 Start Qty: 30.00 *30* Cust Item ID:
 Required Date: 7/18/2017 Req'd Qty: 30.00 *30* Customer:

Reference:

Approvals: Process Plan: W Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D4820	A

100	FLOW WATER JET	0.00							
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100
 Waterjet

FLOW CNC Waterjet

Memo 0.47

1-Cut as per Dwg D4820

Dwg Rev: A

Prog Rev: A

2-Debur as required

(32)

06/17/09

110	QC2- Inspect parts off machine FAI/FAIB	0.00							
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110
 QC

Quality Control

Memo 0.30

(32)

06/17/09

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N900040100

Setup Start *NS1*

Stop *NS2*

Start Date: 6/9/2017 **Start Qty:** 30.00

30

Cust Item ID:**Required Date:** 7/18/2017 **Req'd Qty:** 30.00

30

Customer:

Reference:

Run Start *NR1*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Stop *NR2*

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

**Insp.
Stamp**

0.00

120

QC

Memo

0.60

Quality Control

DAS

38

— 98 —

JUN 12 2017

0.16

140

Brake NC

Memo

0.67

Brake NC

Bend and c'sink hole as per Dwg D4820

DAS
30
9-89

DAS
36
9-89

JUN 15 2017

QC5- Inspect part completeness to step on W/O

0.00

150

QC

Memo

0.60

Quality Control

DAS
38
9-89

JUN 16 2017

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Item ID: D4820-3 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Fpc Clip Profile
Start Date: 6/9/2017 Start Qty: 30.00 ***30*** Cust Item ID:
Required Date: 7/18/2017 Req'd Qty: 30.00 ***30*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180 *180* Packaging Packaging	Identify as per dwg & Stock Location: _____ Memo LOCATION : GA	0.00 0.30				32			DAS 6 9-89
190 *190* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 3.00							17/6/21 2017

DAS
21
9-89

JUN 19 2017

Picklist Print

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Work Order ID: 162717

162717

Parent Item: D4820-3

D4820-3

Parent Item Name: Fpc Clip Profile

Start Date: 6/9/2017

Required Date: 7/18/2017

Start Qty: 30.00

Required Qty: 30.00

Comments: IPP REV:A NEW ISSUE 13-04-15 JLM VERIFIED BY:DD

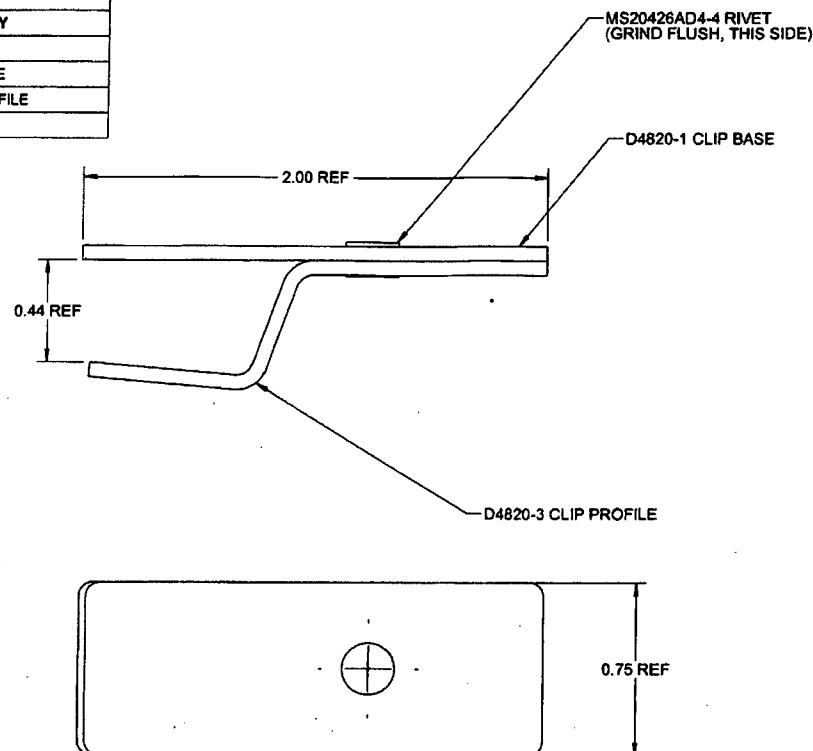
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S16GA		Purchased			No	100	sf	78.7620	0.02	0.631579			
M304S16GA									**				
304/316 Sheet .063													

06/17/06/09

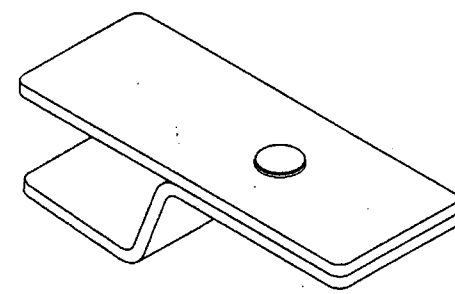
<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
MAT010	78.762	
m136896	0.3	
m137110	0.532	
m137175	1.1	
m137263	0.27	
m137341	5.7	
m137400	70.86	

135
135

ITEM	QTY -041	P/N	DESCRIPTION
	X	D4820-041	CLIP ASSY
1	1	D4820-1	CLIP BASE
2	1	D4820-3	CLIP PROFILE
3	1	MS20426AD4-4	RIVET



W/O 162710

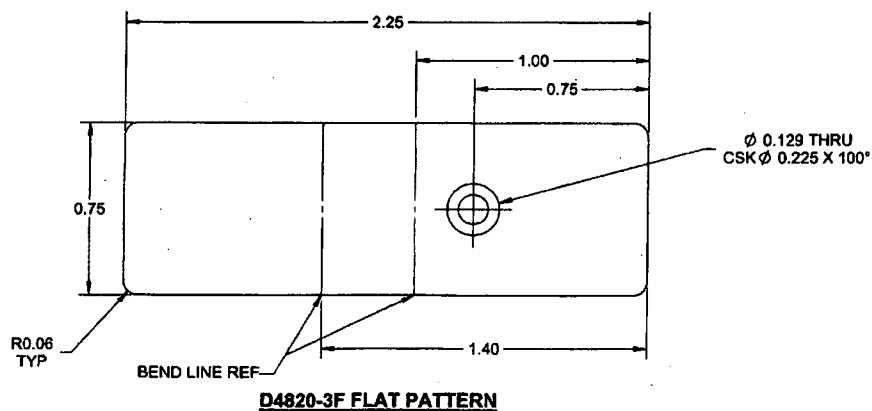
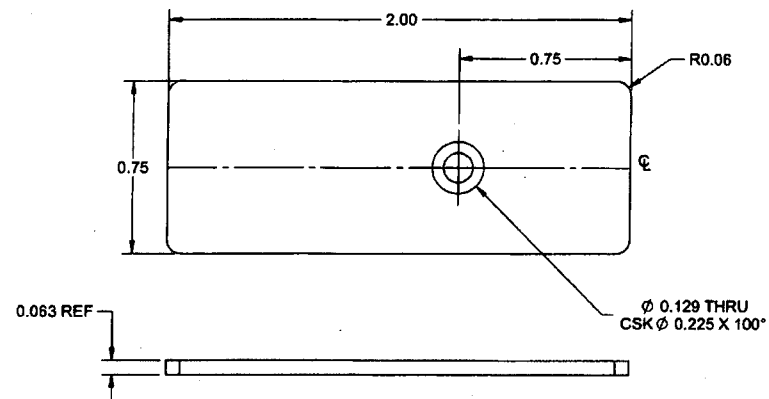
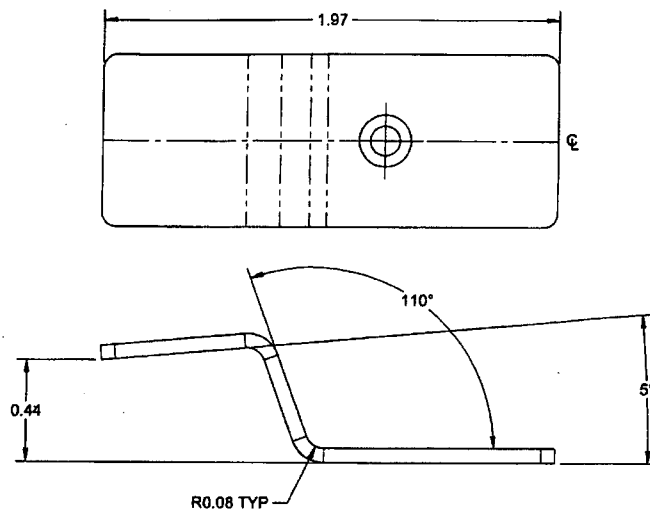


D4820-041 CLIP ASSY

RELEASED
2013-04-18
mp

- NOTES:**
- 1) MATERIAL: N/A
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4820-041" USING FINE POINT PERMANENT MARKER, QSI 044, METHOD 6.1
 - 7) WEIGHT: 0.06 lbs

A	NEW ISSUE	DB	13.04.10
REV.	DESCRIPTION	BY	DATE
DESIGN	DB	DART AEROSPACE LTD	
DRAWN	DB	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>AP</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>AP</i>	D4820	SHEET 1 OF 2
APPROVED	<i>AP</i>	TITLE	SCALE
DE APPR.	<i>AP</i>	CLIP ASSY	NTS
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RELEASED
2013-04-18

NOTES:

- 1) MATERIAL: AISI 304/316 SS, 0.063" THICK AS PER DART SPEC M304S18GA1P OR MIL-S-5059 OR AMS 5513 (304) OR AMS 5524 (316) OR ASTM A240 OR ASME SA240
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: D4820-1: 0.03 lbs, D4820-3: 0.03lbs

DESIGN	DB	DART AEROSPACE LTD	
DRAWN	DB	HAWKESBURY, ONTARIO, CANADA	
CHECKED	AP	DRAWING NO.	REV. A
MFG. APPR.	TH	D4820	SHEET 2 OF 2
APPROVED	TH	TITLE	SCALE
DE APPR.	TH	CLIP ASSY	NTS
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